



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2654-1**

**Job Sheet 172076**



**Part No:** D2654-1

**Job Qty:** 8 ea

**Part Name:** Web



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 2/12/18

**Job Tracking No:**

**Due Date:** 2/19/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV F SHEET 1 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 8 Ea  |            | 2/17/18  | 0.00      | 0.00    | Start Up Skid tubes-2 |           | M66            |
| 100   | Skid tubes         | 8 pcs |            | 2/17/18  | 0.00      | 3.72    | Skid tubes-3          |           | M66            |
| 110   | QC                 | 8 pcs |            | 2/17/18  | 0.00      | 0.00    | QC5                   |           | BE             |
| 120   | HandFinish         | 8 pcs |            | 2/19/18  | 0.00      | 1.29    | HandFinish1           |           | SA 18-3-20     |
| 130   | QC                 | 8 pcs |            | 2/19/18  | 0.00      | 0.00    | QC7-1                 |           | BE             |
| 140   | Packaging          | 8 pcs |            | 2/19/18  | 0.00      | 0.00    | Packaging3-1          |           | DA M66         |
| 150   | QC21-SA            | 8 Ea  |            | 2/19/18  | 0.00      | 0.00    | QC21                  |           | 21 MAR 28 2018 |

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654 3-Descriptions: Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends  
140 - LOCATION : LG002

### Job BOM

| Part / Item | Component Name        | Quantity    | Operation             | Container |
|-------------|-----------------------|-------------|-----------------------|-----------|
| D2600-5-108 | Extrusion I-Beam Thin | 8 Ea (1 ea) | 90-Start up Operation | 145238    |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2600-5-108    | 8        | 118       | 0         |

### Part Specifications

Specifications could not be found.

Plex 2/12/18 1:12 PM Dart.Gagnon.Michelle



**Container No: S054750**



**Part: D2654-1**

**Job No: 172076**

**Serial No/Batch: S054750**

**Revision:**

**Inspector:**

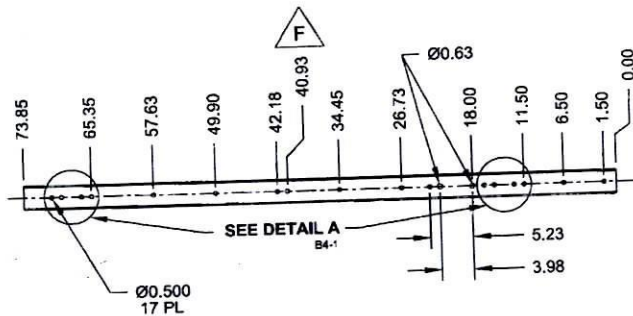
**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Date: 03/26/18**

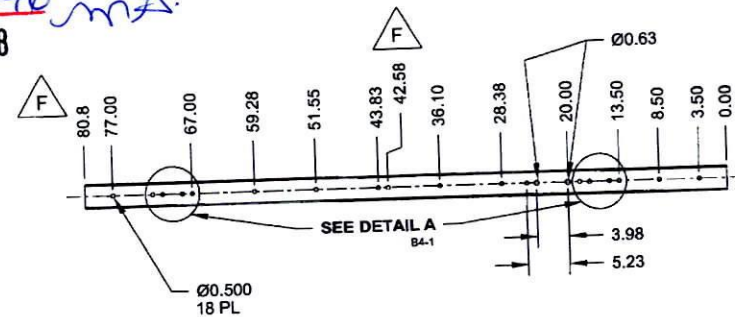
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 172076 *mz*

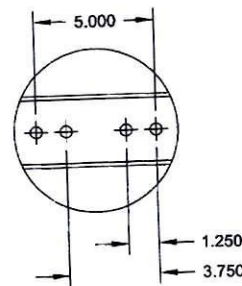
FEB 13 2018



D2654-1 WEB



D2654-3 WEB



DETAIL A

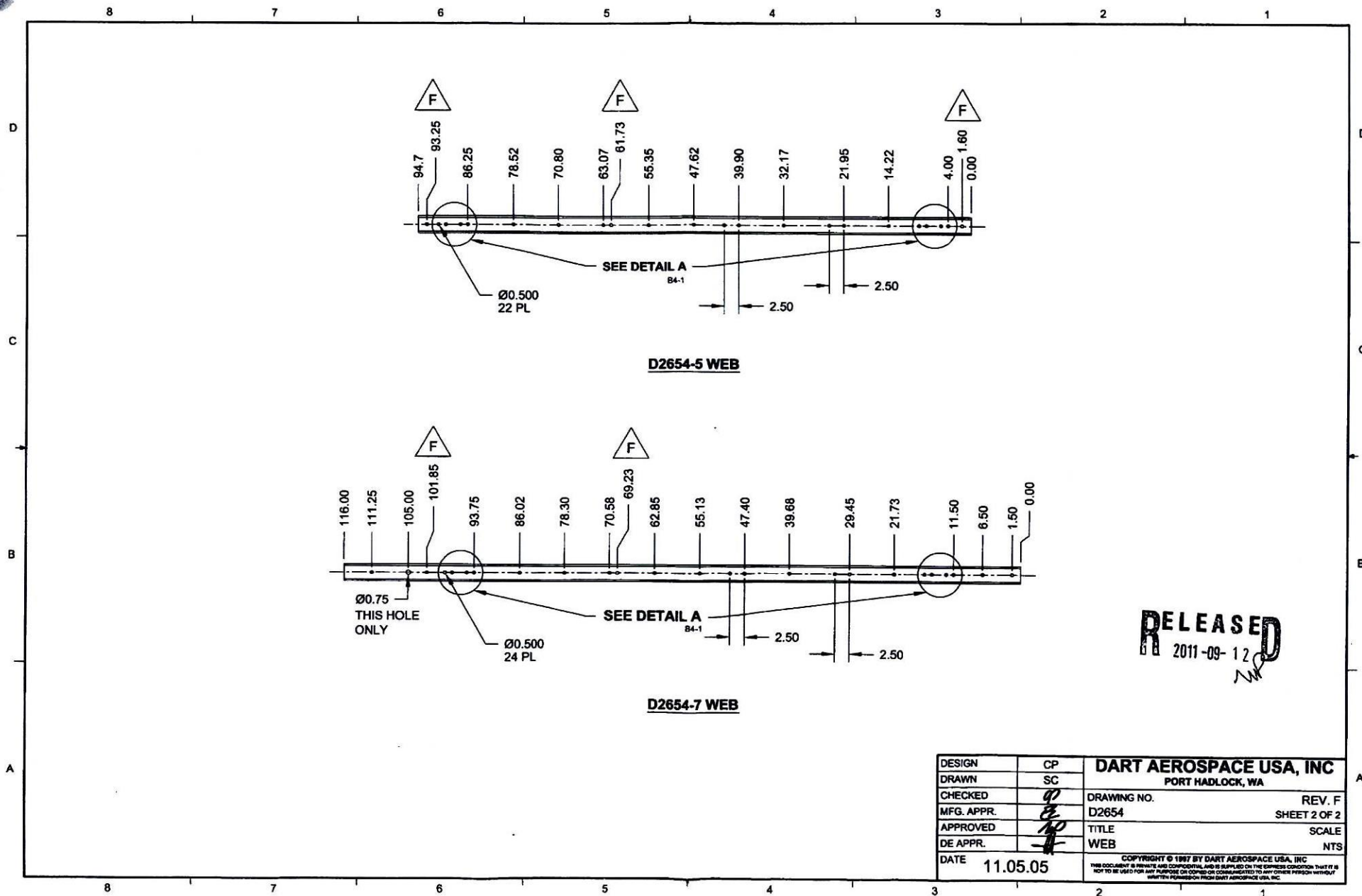
C2-1  
C3-1  
C6-1  
C8-1  
D3-2  
D6-2  
B3-2  
B6-2

RELEASED  
2011-09-12

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

| REV.       | DESCRIPTION                                                                | BY                                                                                                                                                                                                                                                                                 | DATE         |
|------------|----------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| F          | ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2 | SC                                                                                                                                                                                                                                                                                 | 11.05.05     |
| E          | CHANGE LENGTHS, REFORMAT                                                   | CP                                                                                                                                                                                                                                                                                 | 04.05.26     |
| D          | GHW HOLES CHANGED TO Ø0.63                                                 | CP                                                                                                                                                                                                                                                                                 | 98.01.15     |
| C          | CHANGED HOLE PATTERN                                                       | CP                                                                                                                                                                                                                                                                                 | 97.10.29     |
| B          | ALTER HOLE PATTERN, 0.500 WAS 0.438                                        | CP                                                                                                                                                                                                                                                                                 | 97.06.28     |
| A          | NEW ISSUE                                                                  | CP                                                                                                                                                                                                                                                                                 | 97.03.25     |
| DESIGN     | CP                                                                         | DART AEROSPACE USA, INC<br>PORT HADLOCK, WA                                                                                                                                                                                                                                        |              |
| DRAWN      | SC                                                                         |                                                                                                                                                                                                                                                                                    |              |
| CHECKED    | <i>JP</i>                                                                  | DRAWING NO.                                                                                                                                                                                                                                                                        | REV. F       |
| MFG. APPR. | <i>JP</i>                                                                  | D2654                                                                                                                                                                                                                                                                              | SHEET 1 OF 2 |
| APPROVED   | <i>JP</i>                                                                  | TITLE                                                                                                                                                                                                                                                                              | SCALE        |
| DE APPR.   | <i>JP</i>                                                                  | WEB                                                                                                                                                                                                                                                                                | NTS          |
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2011-09-12

|            |                    |                                                                                                                                                                                                                                                                                        |              |
|------------|--------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | CP                 | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                         |              |
| DRAWN      | SC                 | PORT HADLOCK, WA                                                                                                                                                                                                                                                                       |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                            | REV. F       |
| MFG. APPR. | <i>[Signature]</i> | D2654                                                                                                                                                                                                                                                                                  | SHEET 2 OF 2 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | WEB                                                                                                                                                                                                                                                                                    | NTS          |
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